

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-016455**Date Inspected:** 25-Aug-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Zhu Zhong Hai.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG components.**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Mr. Shailesh Wadkar was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS)

Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

OBG Trial Assembly Yard:

This QA Inspector observed the following work in progress:

OBG Seg 9DW and Seg 9EW:

Repair welding on weld joint no: DP687-001-020. Welding process was identified as Shielded Metal Arc Welding (SMAW). The welder was identified as 044551 and was observed welding in the 3G position. ZPMC Quality Control (QC) was identified as Zhu Yuan Yuan. The welding variables recorded by QC appeared to comply with WPS: 485-SMAW-3G(3F)-Repair-1. Repair welding was done as per Welding Repair Report (WRR): B-WR-14680 Rev-0.

OBG Seg 9CW and Seg 9DW:

Repair welding on weld joint no's: SP657-001-034 and 035. Welding process was identified as SMAW. The welder was identified as 041713 and was observed welding in the 3G position. ZPMC QC was identified as Zhu

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Yuan Yuan. The welding variables recorded by QC appeared to comply with WPS: 345-SMAW-3G(3F)-FCM-Repair-1. Repair welding was done as per WRR: B-WR-14654 Rev-0 and B-WR-14655 Rev-0; for the respective welds.

OBG Seg 9BW:

Repair welding on weld joint no: SSD25-075-174. Welding process was identified as SMAW. The welder was identified as 045196 and was observed welding in the 2G position. ZPMC QC was identified as Zhong Guo Hai. The welding variables recorded by QC appeared to comply with WPS: 345-SMAW-2G(2F)-Repair-1. Repair welding was done as per WRR: B-WR-14806 Rev-0.

Repair welding on weld joint no: SSD25-075-117. Welding process was identified as SMAW. The welder was identified as 045196 and was observed welding in the 4G position. ZPMC QC was identified as Zhong Guo Hai. The welding variables recorded by QC appeared to comply with WPS: 345-SMAW-4G(4F)-Repair-1. Repair welding was done as per WRR: B-WR-14808 Rev-0.

OBG Seg 10AW:

The SMAW process on weld joint no's: DP675-001-013 to 018. The welder is identified as 067665 and was observed welding in the 4F position. ZPMC QC was identified as Zhou Peng. The welding variables recorded by QC appeared to comply with WPS: B-T-4114-1.

The SMAW process on weld joint no's: DP688-001-013 to 018. The welder is identified as 067829 and was observed welding in the 4F position. ZPMC QC was identified as Zhou Peng. The welding variables recorded by QC appeared to comply with WPS: B-T-4114-1.

The Flux Cored Arc Welding (FCAW) process on weld joint no: SEG059B-PP88-026. The welder is identified as 202384 and was observed welding in the 3F position. ZPMC QC was identified as Zhou Peng. The welding variables recorded by QC appeared to comply with WPS: B-T-2233-TC-U4b-F.

OBG Seg 10BW:

The SMAW process on weld joint no's: DP676-001-007 to 012. The welder is identified as 067665 and was observed welding in the 4F position. ZPMC QC was identified as Zhou Peng. The welding variables recorded by QC appeared to comply with WPS: B-T-4114-1.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

No significant conversations were reported on this date.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or

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remedial efforts please contact Eric Tsang; phone: 15000422372., who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Wadkar,Sailesh	Quality Assurance Inspector
<b>Reviewed By:</b>	Peterson,Art	QA Reviewer

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